

# Work Order ID 63084

October 20, 2010 3:09:08 PM



Page 1

Item ID: D3890-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Side

Start Date: 10/20/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/21/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: 11

Date: 10/10/20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3890	A

100 0.00



Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3890-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110 0.00



QC

Memo

Quality Control

810-10-20

②

810-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63084**

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Page 2

Item ID: D3890-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Panel, Side

Start Date: 10/20/10 Start Qty: 2.00

Cust Item ID:

Required Date: 10/21/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2

10/10/21

130

0.00



Small Fab

Memo

0.00

Small Fab

Deburr if necessary

= 7 m.p 10/10/21

(2x)

140

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Thermoform using mold DT9489 as per dwg

(x2)

Dh  
10/10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 63084




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Page 3

Item ID: D3890-041 Accept  Setup Start   
Revision ID: Stop   
Item Name: Panel, Side  
Start Date: 10/20/10 Start Qty: 2.00  Cust Item ID:  
Required Date: 10/21/10 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				2			10/10/21
160  Packaging Packaging	Pick Kit  Memo	0.00  0.00				②			
170  Small Fab Small Fab	 Memo 1- Bond gasket to smooth side of panel as per dwg A/R 3M 1300 adhesive Batch: 115230 => m-l 10/10/21	0.00  0.00				2X			

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63084**

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Item ID: D3890-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Side

Start Date: 10/20/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/21/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				2			10/20/10
190  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo PDPG3712 6308	0.00  0.00							10/10/21
200  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							10/10/21

10.10.10

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 63084

Parent Item: D3890-041

Parent Item Name: Panel, Side



Start Date: 10/20/10

Required Date: 10/21/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.125-F60029-04		Purchased	No			100	sf	1,253.803	3.618	7.616842			
---------------------	--	-----------	----	--	--	-----	----	-----------	-------	----------	--	--	--



GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT

1253.8038

115261

1253.8038

D3890-3

Manufactured No

160

Each

0.0000

2

4



Gasket

B 63088



115261  
SN 10/10/21

2

27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

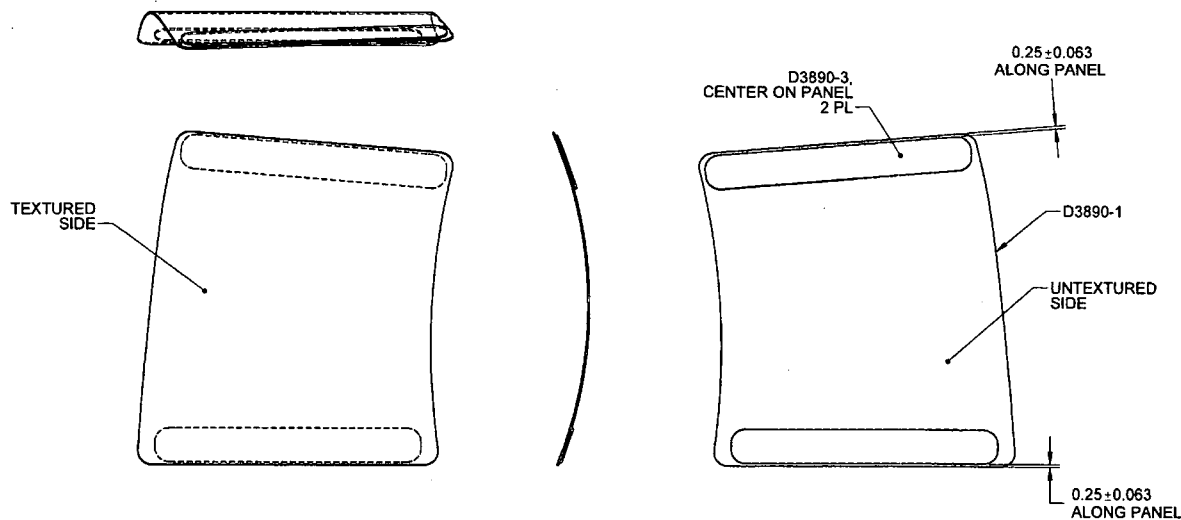
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3890-041	PANEL, SIDE
2	1	D3890-1	PANEL
3	2	D3890-3	GASKET
5	A/R	3M 1300	ADHESIVE

**D3890-041 PANEL, SIDE**

## NOTES:

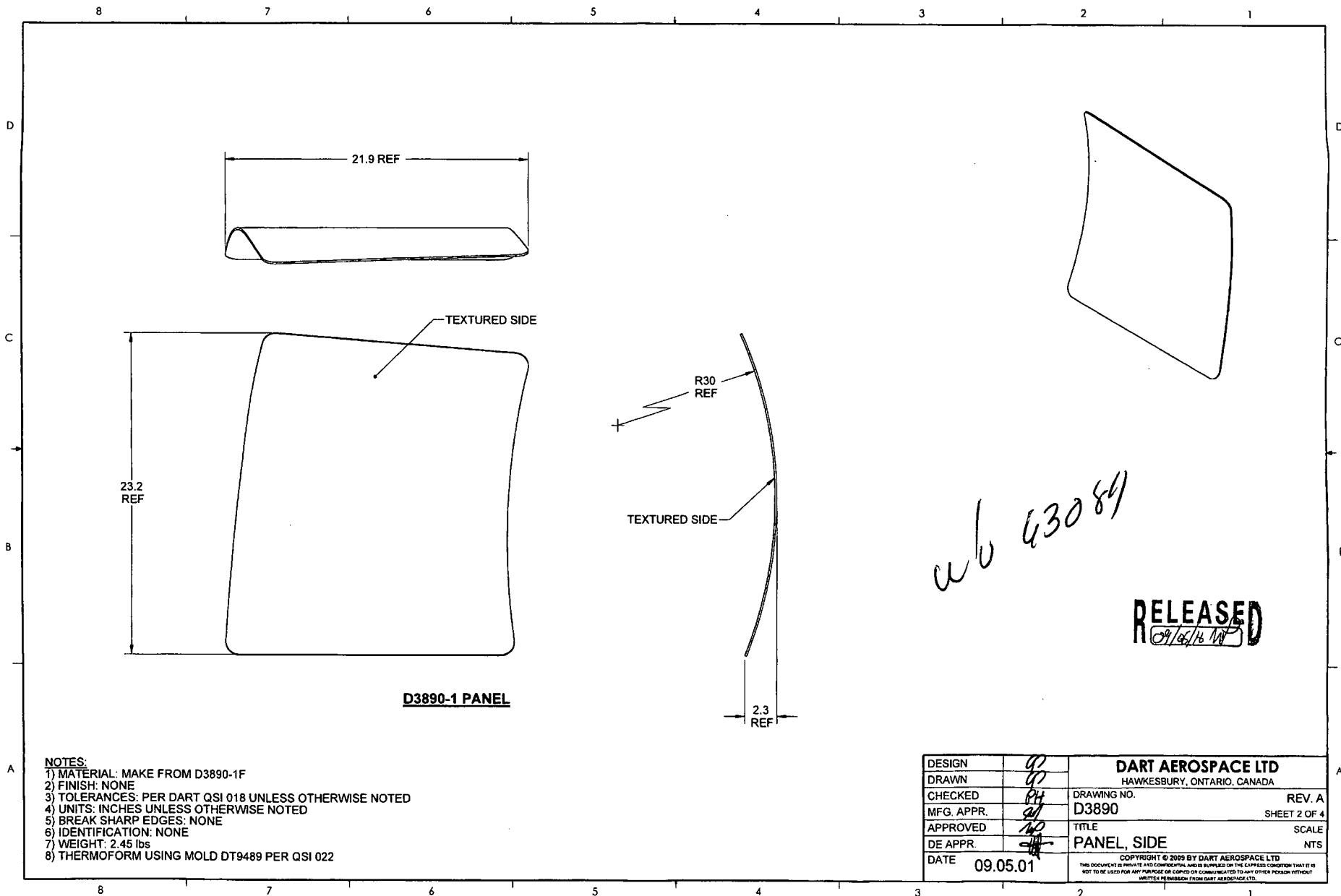
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3890-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.48 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. G3084

2/10-10-20

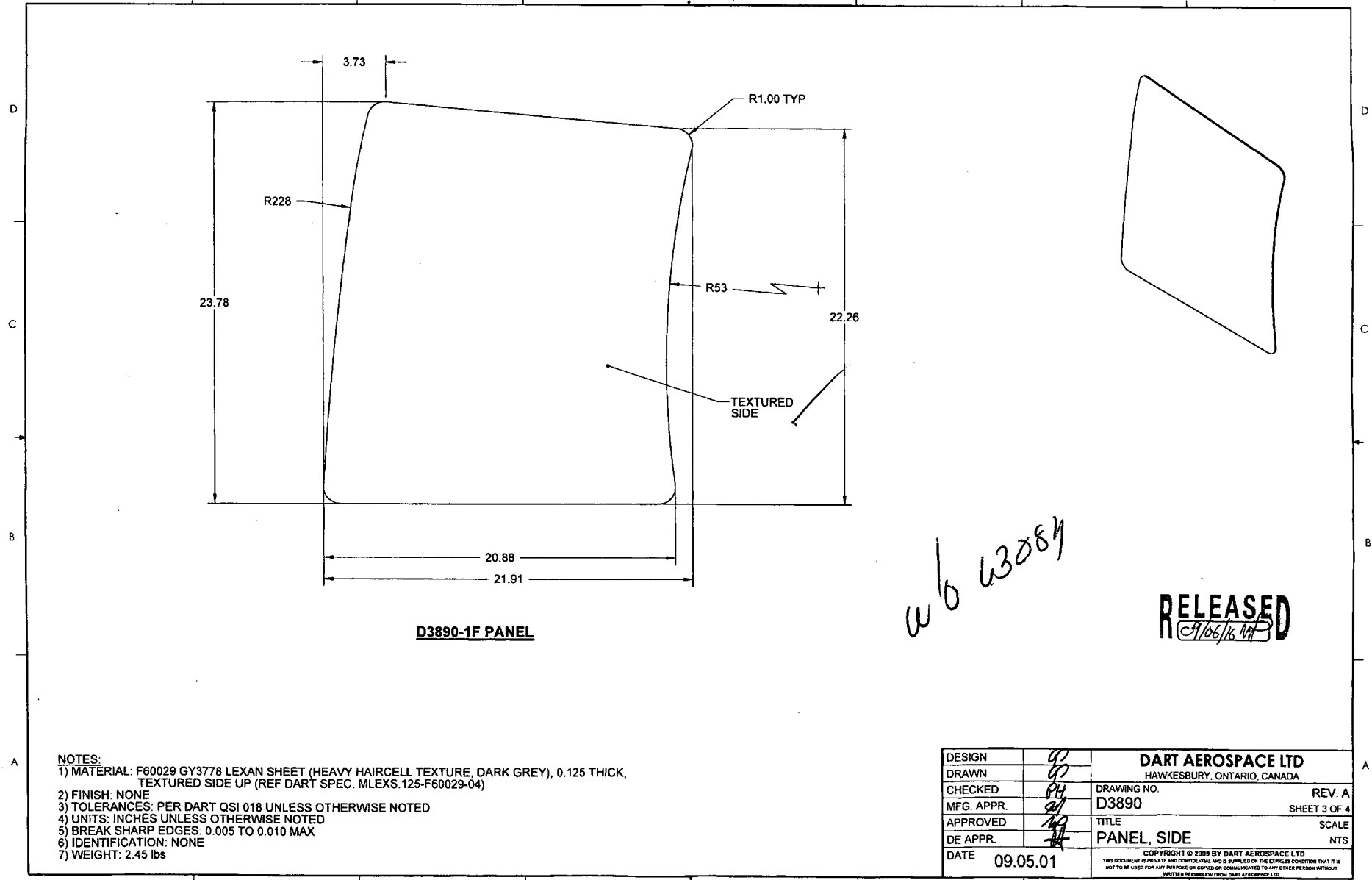
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09/05/01

A NEW ISSUE		CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>90</u>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>90</u>		
CHECKED	<u>PH</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>21</u>	D3890	SHEET 1 OF 4
APPROVED	<u>21</u>	TITLE	SCALE
DE APPR.	<u>21</u>	PANEL, SIDE	NTS
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8 7 6 5 4 3 2 1



w/b 43084

**RELEASED**  
9/06/16 M

**NOTES:**

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.45 lbs

DESIGN	00	<b>DART AEROSPACE LTD</b>	
DRAWN	00	HAWKESBURY, ONTARIO, CANADA	
CHECKED	04	DRAWING NO.	REV. A
MFG. APPR.	01	D3890	SHEET 3 OF 4
APPROVED	01	TITLE	SCALE
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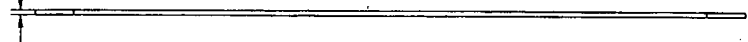
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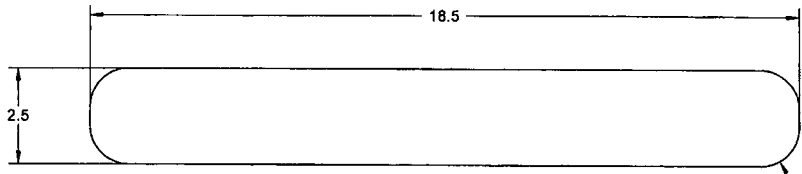
D

0.125  
REF



C

C



R1.0  
TYP

**D3890-3 GASKET**

B

B

*u/w 430841*

**RELEASED**  
*09/06/14 MP*

A

A

**NOTES:**

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK  
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	<i>92</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>92</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	<b>D3890</b>	SHEET 4 OF 4
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	<b>PANEL, SIDE</b>	NTS
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8 7 6 5 4 3 2 1